



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE117W3-5
Job Sheet 203707



Part No: RBE117W3-5

Job Qty: 8 pcs

Part Name: Hook



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/26/19

Job Tracking No:

Due Date: 1/17/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE117-W3 Rev.B IPP Rev. A 18.10.11 New issue DP Verify DD/IPP Rev. B 19.05.21 drawing revision
DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Omax - 1	8 pcs	1/17/20	1/17/20	0.17	4.00	Waterjet - Omax		2/19/12/06
110	QC 2	8 pcs	1/17/20	0.00	0.00		QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		2/19/12/06
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
120	Conventional Mill - 1 - B4B	8 pcs	1/17/20	0.25 4.00	Conventional Mill - 1 - B4B	#19/12/10
					Conventional Mill - 2 - B4B	
130	QC 2	8 pcs	1/17/20	0.00 0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	#19/12/10
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
140	QC 8	8 pcs	1/17/20	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	

				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	DAS
				QC 8 - 23	23
				QC 8 - 57	9-89
				QC 8 - 76	
				QC 8 - 61	
150	Packaging 3-1 - Stock - B4B 8 pcs	1/17/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160	QC 21 - SA	8 pcs	1/17/20	0.00 0.00	
					DAS
				QC 21 - SA - 21	21
				QC 21 - SA - 70	DEC 1 6 2019
				QC 21 - SA - 53	9-89
Part Op 100 - OMAX (Waterjet 2) 1-Cut as per Dwg Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - (Manufacture as per dwg) 1-Machine as per DWG. 2-Deburr 130 - (QC2- Inspect parts off machine FAI/FAIB) 140 - (QC8- Inspect parts - second check) 150 - (Identify as per dwg & Stock Location: <u>WHS</u>) 160 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
MT-HRS-P-0.500	Hot Rolled Steel Plate 0.500" (44W)	.7360 sf (.092 ea)	100-Waterjet - Omax - 1	5171947	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Omax - 1	MT-HRS-P-0.500	1	30	0

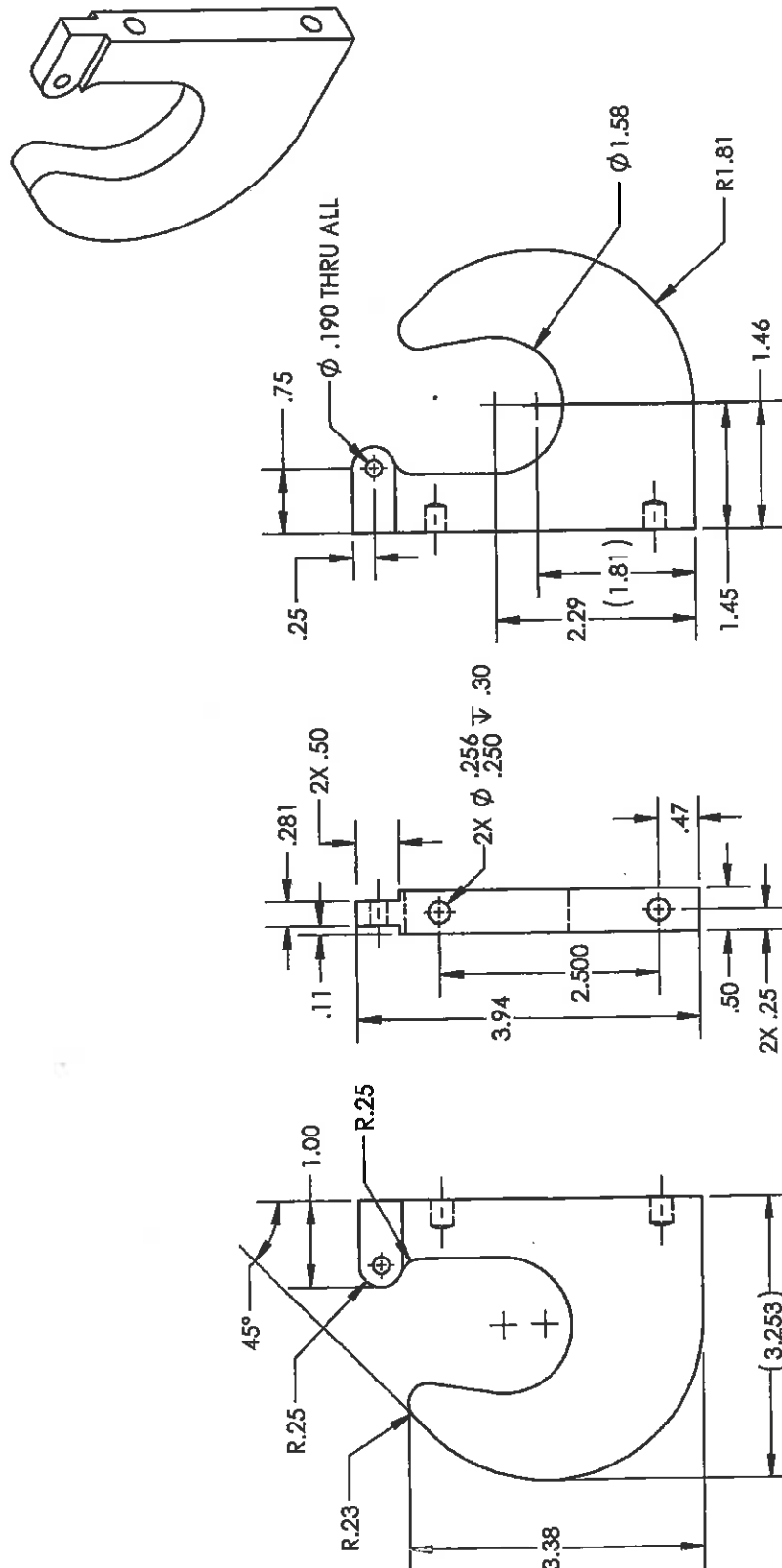
Part Specifications

Specifications could not be found.

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REVISIONS

REVISIONS		DATE	INITIAL	APPROVED
DESCRIPTION				



DART
AEROSPACE

TITLE	DATE	BY	CHKD	APP'D
MAIN ROTORHEAD REMOVAL/INSTALLATION HOIST	01-01-00	0000	0000	0000

OWG NO. RBE117-W3-5

MAT'L	1018/1020 CR
HEAT	
FINISH	SEE -1 WELDMENT
SPEC	
DRAWN BY:	CLOUGH
CHECKED:	DUERFELDT
APPROVED:	ANDERSON

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
FRACTIONS 3/16 ANGLES 24°
XX ± .010 SURFACES = 125
XX ± .01 ANGLES 24°
X ± .1 SURFACES = 125
1. BREAK ALL SHARP EDGES
2. DIMENSIONAL LIMITS APPLY
3. INTERPRET DIM AND TOL PER
ASME Y14.5M-2009

QA APPR:	LINDSAY	USED ON MODEL
APPROVED:	GILBERT	EC145

SCALE	1:2	DATE	2010-08-05	SHEET 4 OF 5
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 203707
19-11-61

HOOK



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐ ☐ ☐
Scrap ☐ ☐ ☐
Use-as-is ☐ ☐ ☐

DEPARTMENT/PROCESS

Skid-tube ☐ ☐ ☐
Machining ☐ ☐ ☐
Large Fab ☐ ☐ ☐

Cross tube ☐ ☐ ☐
Small Fab ☐ ☐ ☐
Finishing ☐ ☐ ☐

Eng. (Non-AW) ☐ ☐ ☐
Prod. Eng. Coord. ☐ ☐ ☐
Rec/Store/Packaging ☐ ☐ ☐
Engineering ☐ ☐ ☐
Water Jet ☐ ☐ ☐
Supplier ☐ ☐ ☐
Quality ☐ ☐ ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QS042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐ ☐ ☐
Manufacturing Process ☐ ☐ ☐
Equip/Tooling ☐ ☐ ☐
Handling/Preservation ☐ ☐ ☐
Material ☐ ☐ ☐
Product Improvement ☐ ☐ ☐
Process Improvement ☐ ☐ ☐
Human Factors ☐ ☐ ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
☐	☐	☐	☐
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
☐	☐	☐	☐
Crushing	BOM/Route	Grain Direction	Drawing
☐	☐	☐	☐
Cracks	Broken/Damage/Defect	Weld	Finish
☐	☐	☐	☐
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
☐	☐	☐	☐
Marks/Chatter	Drill Holes	Out of Sequence	Misread
☐	☐	☐	☐
Mislabeled	Fit/Function	Off-set/Set-up	
☐	☐	☐	

Other/Details: _____

DART AEROSPACE LTD		Work Order: 203707
Description: Hook		Part Number: RBE117W/3-5
Inspection Dwg: RBE117 - Rev: B		Page 1 of 1

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INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
CNC						
1.00	+/- .030	1.006	✓		Vernier JVDs	
3.38	+/- .030	3.386	✓			
3.253	+/- .010	3.257	✓			
0.50	± 0.030	0.490	✓			
3.94	"	3.945	✓			
Ø 1.58	"	1.570	✓			
R.25	"	0.250	✓			
R.23	"	0.230	✓			
R1.81	"	1.810	✓			
1.460	"	1.460	✓			
2.29	"	2.29	✓			
1.81	"	1.81	✓			
45°	± 1/2°	45°	✓			
Manual Milling						
0.25	± 0.030	0.250	✓		Vernier JVDs	
0.75	"	0.750	✓			
0.190	± 0.010	0.191	✓			
0.50 (2x)	± 0.030	0.503	✓			
0.11	"	0.105	✓			
0.281	± 0.010	0.280	✓			
0.47	± 0.030	0.468	✓			
2.500	± 0.010	2.500	✓			
0.250/0.256	MIN / MAX	0.250	✓			
0.30	± 0.030	0.310	✓			
0.25	"	0.245	✓			
				DAS		

Measured by: <i>W / or</i>	Audited by: <i>WJS</i>	Preliminary Approval:
Date: 19/12/10	Date: 19/12/14	Date:

Rev	Date	Change	Revised by	Approved
A	14.07.14	New Issue	KJ	